

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008476**Date Inspected:** 08-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zang Yaxu/Li Zhi jiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay #3

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(FB016-041-043)

-(FB016-044-043)

-(FB024-010-148)

-(CA072-069, 070)

-(CA072-021, 022)

-(CA075-059, 060)

-(CA075-045, 046)

-(CA075-017, 018)

-(CA076-109, 110)

-(CA076-053, 054)

-(CA078-077, 078)

-(CA078-049, 050)

-(CA075-101, 102)

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Cross Beam-CB6

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(CB202F-006-001, 002)

This QA inspector observed the following work in progress:

Bay#3

SAW welding of weld joint CB202F-014-001 located on CB202-014. Welder is identified as 062406 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Root Pass performed by FCAW welding of weld joint CB202F-014-002 located on CB202-014. Welder is identified as 208035 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joints FB003-198-017, 018, 029 and 030 located on FB003-198. Welder is identified as 044830 (3G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay#2

SAW welding of weld joint FB3022-001-017 located on FB3022-001. Welder is identified as 250050 (1G). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SAW welding of weld joint FB3098-001-018 located on FB3098-001. Welder is identified as 250050 (1G). ZPMC QC-CWI is identified as Zhang Yaxu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Patel,Hiranch

Quality Assurance Inspector

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Reviewed By: Prue,Erik

QA Reviewer